

Work Order ID 60012

Tuesday, June 22, 2010 3:22:25 PM



Page 1

Item ID: D4044-041

Accept



Setup Start



Revision ID:

Item Name: Fwd Rib Assembly

Stop



Start Date: 6/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 6/22/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4044

A

100

0.00



Large Fab

Large Fab

Memo

0.00

1- Cut tube 60" and remove identification markings

2- Bend tube with manuel pipe bender as per template DT9579 (Make first line at 15.00")

3- Drill and chamfer holes in D4044-1 as per dwg D4044

4- Trim access tube material to finish size as per dwg D4044

5- weld bushing as per dwg D4044

A/R S.S. rod Batch: M108775

6- grind welds flush

①

SAQ 10-06-23

① PD 10.06.23

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/23

②

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/06/03



Quality Control

130

Identify as per dwg & Stock Location basket

0.00



Packaging

Memo

0.00

① PD 10.06.23

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/06/24

Quality Control

PD 10-6-24

①

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Picklist Print

Tuesday, June 22, 2010 3:22:28 PM

Page 1

Work Order ID: 60012

Parent Item: D4044-041

Parent Item Name: Fwd Rib Assembly

Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

96.0000

3

3



Bushing



RD 10.06.23

Location

Loc Qty

Loc Code

WA

96

54072

9

59419

45

59644

42

(3)

D4021-9

Manufactured

No

100

Each

24.0000

4

4



Bushing



RD 10.06.23

Location

Loc Qty

Loc Code

WA

24

56094

2

58701

6

59838

16

(5)

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Page 2

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Parent Item: D4044-041

Parent Item Name: Fwd Rib Assembly

Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.049

Purchased

No

100

f

446.7945

5

5.263158



10-06-23 SAD

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

146.7944919

113763

0

114323

28.3020789

114677

14.34201

114835

104.150403

526158

MAT017

3.68448E-05

114298

3.6845E-05

WA

300

114992

300

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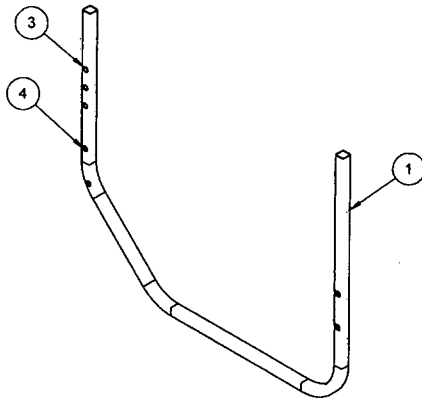
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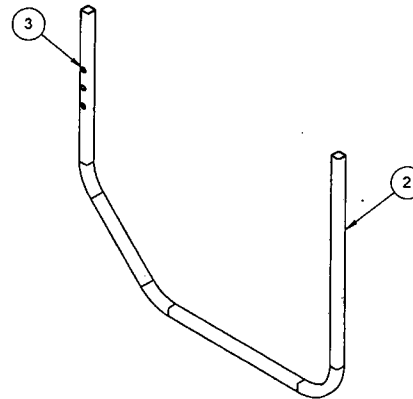
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 60012

BS 10-6-22

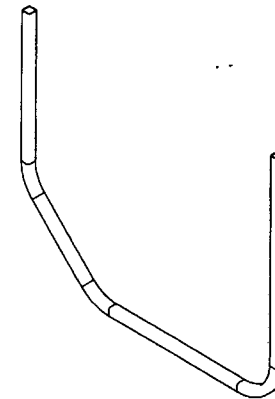
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4044-041	FWD RIB ASSY
		X	D4044-043	CENTER RIB ASSY
1	1		D4044-1	FWD RIB
2		1	D4044-3	CENTER RIB
3	3	3	D3759-1	BUSHING
4	4		D4021-9	BUSHING



D4044-041 FWD RIB ASSEMBLY



D4044-043 CENTER RIB ASSEMBLY



D4044-5 AFT RIB

RELEASED
 2010-02-16
JP

REV.	NEW ISSUE		RF	10.01.29
DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>JP</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>JP</i>	D4044	SHEET 1 OF 5	
APPROVED	<i>JP</i>	TITLE	SCALE	
DE APPR.	<i>JP</i>	RIB ASSEMBLY	NTS	
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

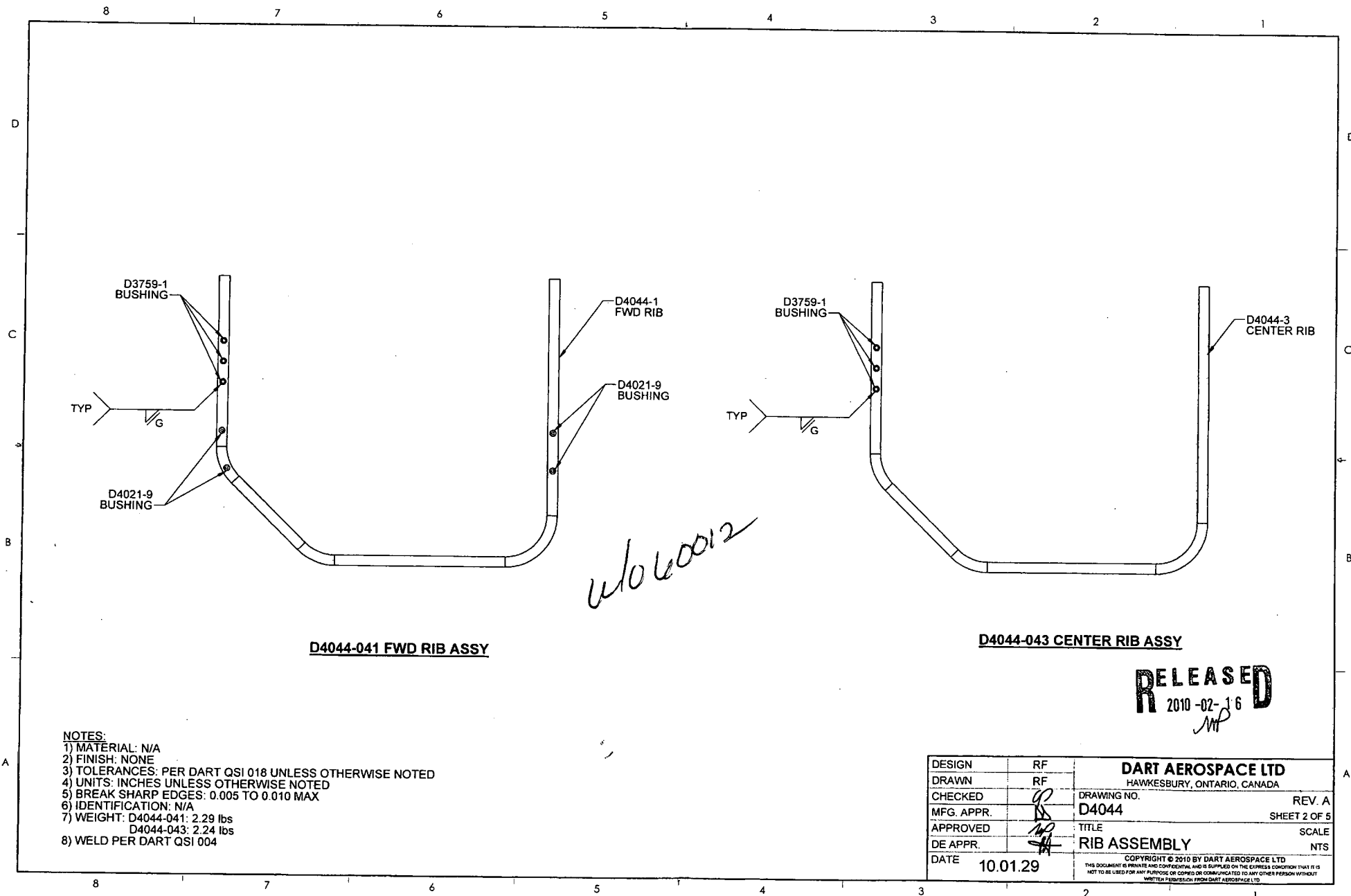
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4044-041: 2.29 lbs
D4044-043: 2.24 lbs
- 8) WELD PER DART QSI 004

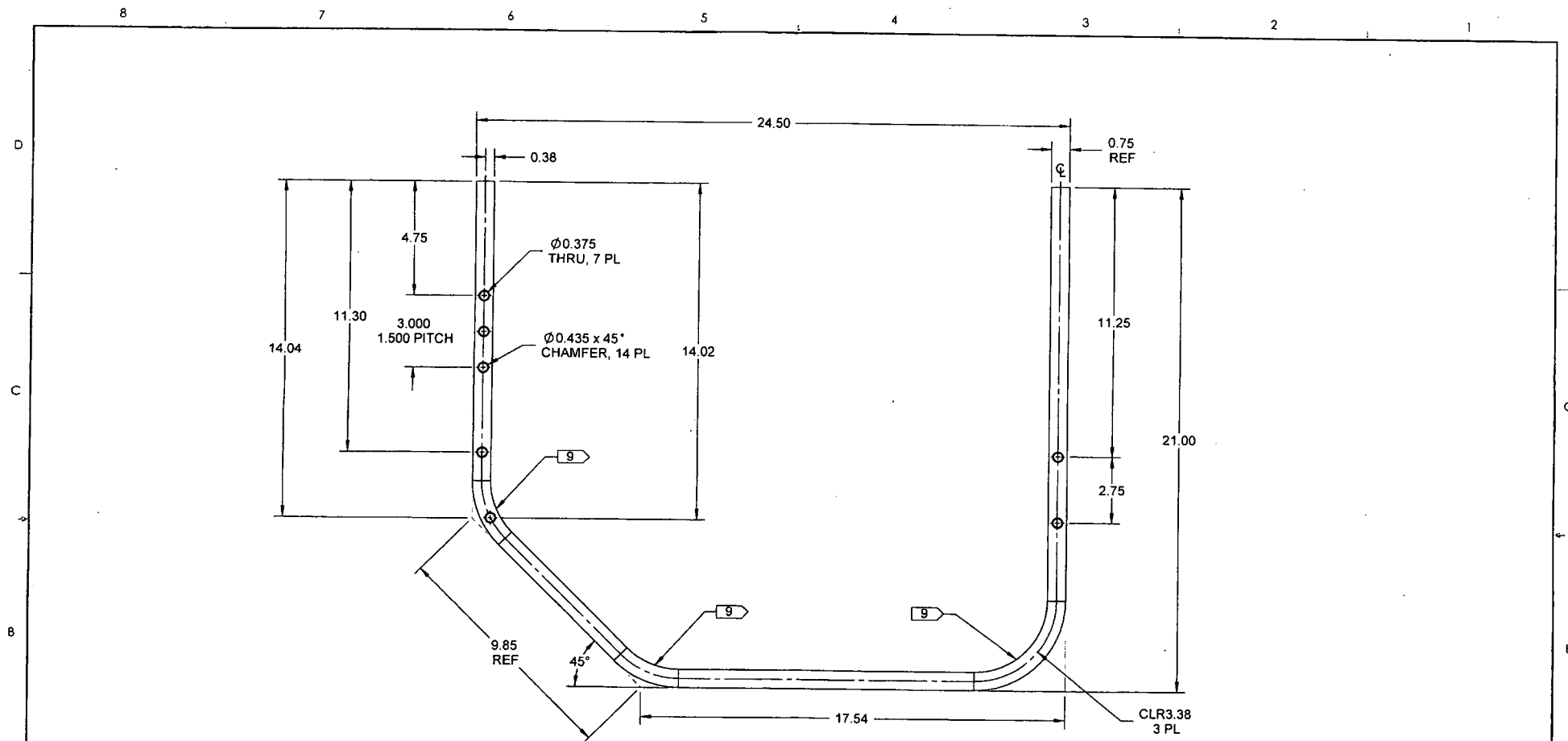
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D4044-1 FWD RIB

RELEASED
2010-02-16
wf

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.750 x 0.75 x 0.049 WALL
REF DART SPEC. M304T50.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.19 lbs
 - 8) TUBE FLAT LENGTH 59.31 REF
 - 9) ALLOWABLE WRINKLING IN BENDS UP TO 0.15" DEEP MAX

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4044	SHEET 3 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	RIB ASSEMBLY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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